



Dart Hawkesbury  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D3492-1**  
**Job Sheet 168667**



Part No: D3492-1

Job Qty: 200 ea

Part Name: Plug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/21/17

Job Tracking No:

Due Date: 12/3/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV E IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty     | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|--------------------|---------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                    |         |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 90    | Start up Operation | 200 Ea  |            | 12/2/17  | 0.00      | 0.00    | Start Up Machining    |           |          |
| 100   | Hardinge           | 200 pcs |            | 12/2/17  | 0.00      | 6.12    | Hardinge              |           |          |
| 120   | QC                 | 200 pcs |            | 12/2/17  | 0.00      | 0.00    | QC8                   |           |          |
| 150   | HandFinish         | 200 pcs |            | 12/2/17  | 0.00      | 0.65    | HandFinish1           |           |          |
| 155   | Outsource          | 200 pcs |            | 12/2/17  | 0.00      | 0.00    |                       |           |          |
| 160   | Powdercoat         | 200 pcs |            | 12/3/17  | 0.00      | 0.32    | Powdercoat1           |           |          |
| 165   | Packaging          | 200 pcs |            | 12/3/17  | 0.00      | 0.00    |                       |           |          |
| 170   | QC                 | 200 pcs |            | 12/3/17  | 0.00      | 0.00    | QC3                   |           |          |
| 180   | Packaging          | 200 pcs |            | 12/3/17  | 0.00      | 0.00    | Packaging3            | FP001     |          |
| 190   | QC21-SA            | 200 Ea  |            | 12/3/17  | 0.00      | 0.00    | QC21                  |           |          |

Part Op 100 - 1-Turn as per Folio FA633 & Dwg D3492 Dwg Rev:

Descriptions: 160 - (Flat End Only) START TIME: 6:50 FINISH TIME: 7:00 O.V.T. 320° M138467

180 - LOCATION : FP001

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated | Std Qty |
|-----------------------|----------------|----------|-----------|-----------|---------|
| 90-Start up Operation | M6061T6R0.625  | 13       | 22        | 0         | 0       |

### Part Specifications

| Spec No | Description | Target/Tolerance               | Limits         | Type | Special Comments |
|---------|-------------|--------------------------------|----------------|------|------------------|
| 1       | Plug        | 0.060inches ± 0.005            | 0.065<br>0.055 |      |                  |
| 2       | Plug        | 0.060inches ± 0.005            | 0.065<br>0.055 |      |                  |
| 3       | Plug        | 0.394inches ± 0.010            | 0.404<br>0.384 |      |                  |
| 4       | Plug        | 0.625inches ± 0.010            | 0.635<br>0.615 |      |                  |
| 5       | Plug        | 0.090inches + 0.000<br>- 0.002 | 0.090<br>0.088 |      |                  |
| 6       | Plug        | 0.500inches ± 0.010            | 0.510<br>0.490 |      |                  |
| 7       | Plug        | 0.050inches + 0.000<br>- 0.002 | 0.050<br>0.048 |      |                  |

**M6061T6R0.625**  
**S008423**

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|   |      |                           |                  |
|---|------|---------------------------|------------------|
| 8 | Plug | 0.050inches $\pm$ 0.010   | 0.060<br>0.040   |
| 9 | Plug | 20.000Degrees $\pm$ 0.000 | 20.000<br>20.000 |

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**DART**  
AEROSPACE  
**S025647**



Plug

**Dart Aerospace Ltd.**  
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CANADA  
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Email: sales@dartaero.com  
www.dartaerospace.com

**PART NO: D3492-1**

**Revision:**

**Operation:**

**Change No:**

**Start up Operation**

**Mfg Date: 12/20/17**

**Job No: 168667**



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## Inventory

| Operation Number                                                    | Operation  | Serial Number | Job    | Quantity | Weight | Original Serial Number | Location           | Container | Status | Added      | Special Comments | Label                                                                               | Supplier | Change No |
|---------------------------------------------------------------------|------------|---------------|--------|----------|--------|------------------------|--------------------|-----------|--------|------------|------------------|-------------------------------------------------------------------------------------|----------|-----------|
| <b>Part Number: D3492-1 Revision: Plug</b>                          |            |               |        |          |        |                        |                    |           |        |            |                  |                                                                                     |          |           |
| 190                                                                 | QC21-SA    | S025647       | 168667 | 200 Ea   | 0      | S025647                | FP001              | Bin       | Stock  | 12/20/2017 | Issue Container  |  |          |           |
| <b>Operation Totals:</b>                                            |            | 1             |        | 200      | 0      |                        |                    |           |        |            |                  |                                                                                     |          |           |
| <b>Part Totals:</b>                                                 |            | 1             |        | 200      | 0      |                        |                    |           |        |            |                  |                                                                                     |          |           |
| <b>Part Number: M6061T6R0.625 Revision: 6061-T6 Round Bar .625"</b> |            |               |        |          |        |                        |                    |           |        |            |                  |                                                                                     |          |           |
| 100                                                                 | Receive Ft | S025645       | 168667 | 1 ft     | 0      |                        | Start Up Machining |           | Stock  | 12/20/2017 | Issue Container  |  |          |           |
| <b>Operation Totals:</b>                                            |            | 1             |        | 1        | 0      |                        |                    |           |        |            |                  |                                                                                     |          |           |
| <b>Part Totals:</b>                                                 |            | 1             |        | 1        | 0      |                        |                    |           |        |            |                  |                                                                                     |          |           |
| <b>Totals:</b>                                                      |            | 2             |        | 201      | 0      |                        |                    |           |        |            |                  |                                                                                     |          |           |

Plex 1/8/2018 8:09 AM Dart.Boucher.Sylvie



DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                                                                                                                                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |  |                                              |  |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|----------------------------------------------|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                                              |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | Step #:                                                                                                                                                                            | QTY Effective :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |  | MRB (QSI042) Approval                        |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                                                                                                                                                                    | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |  | Completed By                                 |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                                                                                                                                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |  | Lead hand / Supervisor Approval Verification |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                                                                                                                                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |  | QC / QA Coordinator Approval                 |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                                                                                                                                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |  |                                              |  |
| <b>Root Cause</b><br><div style="display: flex; justify-content: space-between;"> <div>           Environment <input type="checkbox"/><br/>           Design <input type="checkbox"/><br/>           Doc/Data <input type="checkbox"/><br/>           Equip/Tooling <input type="checkbox"/><br/>           Handling/Pre <input type="checkbox"/><br/>           Material <input type="checkbox"/><br/>           Internal Transport <input type="checkbox"/><br/>           Tribal Knowledge <input type="checkbox"/><br/>           LOA <input type="checkbox"/><br/>           Substation <input type="checkbox"/><br/>           Past Expiry Date <input type="checkbox"/><br/>           Misidentified <input type="checkbox"/> </div> <div>           No Re-verification <input type="checkbox"/><br/>           Operator <input type="checkbox"/><br/>           Offset/Setup <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Training <input type="checkbox"/><br/>           Use for Testing <input type="checkbox"/><br/>           Poor Information <input type="checkbox"/><br/>           Rushing <input type="checkbox"/><br/>           Product Improvement <input type="checkbox"/><br/>           Process Improvement <input type="checkbox"/><br/>           Manufacturing Process <input type="checkbox"/><br/>           Past Due <input type="checkbox"/> </div> </div> |                                                                                                                                                                                    | <b>FAULT CATEGORY</b><br><div style="display: flex; justify-content: space-between;"> <div>           Pressure/Forced <input type="checkbox"/><br/>           Bending <input type="checkbox"/><br/>           Centre Not Concentric <input type="checkbox"/><br/>           Cracks <input type="checkbox"/><br/>           Crimp/Kink/Ripple/Wave <input type="checkbox"/><br/>           Cuffs <input type="checkbox"/><br/>           Crushing <input type="checkbox"/><br/>           Heat Treat <input type="checkbox"/><br/>           Wave/Twist in Tube <input type="checkbox"/><br/>           Marks/Chatter <input type="checkbox"/> </div> <div>           Temperature/Cure <input type="checkbox"/><br/>           Set-up <input type="checkbox"/><br/>           BOM/Route <input type="checkbox"/><br/>           Broken/Damage/Defect <input type="checkbox"/><br/>           Inspection Incomplete/Unqualified <input type="checkbox"/><br/>           Contamination <input type="checkbox"/><br/>           Countersink <input type="checkbox"/><br/>           Cut Too Short <input type="checkbox"/><br/>           Instructions Incomplete/Unclear <input type="checkbox"/><br/>           Drill Holes <input type="checkbox"/> </div> <div>           Power Loss/Surge <input type="checkbox"/><br/>           Folio/Program <input type="checkbox"/><br/>           Grain <input type="checkbox"/><br/>           Weld <input type="checkbox"/><br/>           Wrong Stock Pulled <input type="checkbox"/><br/>           Out of Sequence <input type="checkbox"/><br/>           Off-set <input type="checkbox"/><br/>           Misabeled <input type="checkbox"/><br/>           Fit/Function <input type="checkbox"/><br/>           Misaligned/off center <input type="checkbox"/> </div> <div>           Positioned Wrong <input type="checkbox"/><br/>           Outside Dimensions <input type="checkbox"/><br/>           Over/Under tolerance <input type="checkbox"/><br/>           Part Incorrect <input type="checkbox"/><br/>           Part Lost/Missing <input type="checkbox"/><br/>           Part Moved <input type="checkbox"/><br/>           Drawing <input type="checkbox"/><br/>           Finish <input type="checkbox"/><br/>           Misread <input type="checkbox"/><br/>           Turning Sequence <input type="checkbox"/> </div> </div> |  |                                              |  |
| OTHER : <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                                                                                                                                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |  |                                              |  |